

CLAIMS

1. An apparatus for reforming the base of a can body, the can body having a substantially cylindrical side wall and an integral base, and the base including an outer annular wall, a support portion, an inner wall and a central dome, the apparatus comprising:

one or more reform rollers;

an actuator for moving the or each roller from a first position adjacent the base of the can to a second position in which the roller contacts either the outer annular wall or the inner wall of the can base in order to reform at least the inner wall of the can base;

and in which the or each reform roller has a textured surface.

2. An apparatus according to claim 1, in which the textured surface has a non-periodic profile with a lay which is either particulate or multi-directional.

3. An apparatus according to claim 1 or claim 2, in which the textured surface of each roller is a spark eroded finish, a carbide deposited finish or a combination of these.

4. An apparatus according to claim 1 or claim 2, in which the textured surface of each roller is a sand or aqua blasted finish.

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5. An apparatus according to any one of claims 1 to 4, in which the apparatus is for internal base reforming and each roller has a thickness which is at least 25% of the height of the inner wall.

6. An apparatus according to claim 5, in which the roller has a first radius which, in use, is at the upper end of the region of contact between the roller and the inner wall and a second radius which is at the lower end of the region of contact, and in which the upper radius is larger than the lower radius.

7. A method of reforming the base of a can body, the can body having a substantially cylindrical side wall and an integral base, and the base including an outer annular wall, a support portion, an inner wall and a central dome, the method comprising:

moving one or more reform rollers from a first position adjacent the base of the can to a second position in which the or each roller contacts either the outer annular wall or the inner wall of the can base in order to reform at least the inner wall of the can base; and

controlling the depth of the dome by using reform rollers which have a textured surface.